

Item	Qty -243	Part Number	Description
1	X	D350-748-243	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D6021-125	CROSSTUBE
3	2	D3502-1	SUPPORT
4	2	D5123-7	CLAMP CUSHION
5	1	AETC-1032	INSERT
6	2	MS21920-20 OR MS21920-21/-22	CLAMP (PER DART SPEC. M-MS21920-20/-21/-22)
7	1	NAS1149C0363R	WASHER (OR AN960C10)
8	1	NAS1635-3-8	SCREW (OR MS51958-63)
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6021-125
FINISHED LENGTH AFTER TURNING = 124.70±0.06 (AFTER BENDING/TRIMMING = 122.70 REF)
- 2) FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCE: PER DART QSI 018 UNLESS OTHERWISE NOTED.
WALL THICKNESS ECCENTRICITY PER DART QSI 038 7.2
MIN. ALLOWABLE WALL IS -0.020 FROM NOMINAL
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-243" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 29.85 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.290 HOLE.
- 9) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.

TURNING

- 10) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.

BENDING

- 11) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES PER SIDE. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D. ON TOP HALF OF BEND, AND 8% ON BOTTOM HALF OF BEND.
- 12) MAX AMPLITUDE OF RIPPLING ALONG BENT PORTION OF THE TUBE IS 0.030 (ZN A1-3)
- 13) MAX TWIST: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.38 (ZN C1-3).

ASSEMBLY

- 14) TO INSTALL D3502-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.02" TO 0.05" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

PRELIMINARY ISSUE

Rev. PA3

4/15/3/3

PA3	NEW ISSUE	CP	15.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN	q2	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	q2		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.		D350-748-243	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	15.01.21	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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14 15
D3502-1 SUPPORT
MS21920-20 CLAMP (OR -21/-22)
D5123-7 RUBBER CUSHION
2 PL

A7-2

A

A

14.00

D350-748-243
BENT TUBE

INSTALL THIS SIDE ONLY, AFTER FINISH:
AETC-1032 INSERT
NAS1149C0363R WASHER
NAS1635-3-8 SCREW

**D350-748-243
ASSEMBLY DETAIL**

MS21920-20 CLAMP
REF

D3502-1 SUPPORT
REF

D5123-7
CLAMP CUSHION
REF

SECTION A-A D4-2
SCALE 6X

PRELIMINARY ISSUE

Rev. PA3

4/15/13

DESIGN	<i>Q</i>	DART AEROSPACE LTD	
DRAWN	<i>Q</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.		D350-748-243	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI AFT)	NTS
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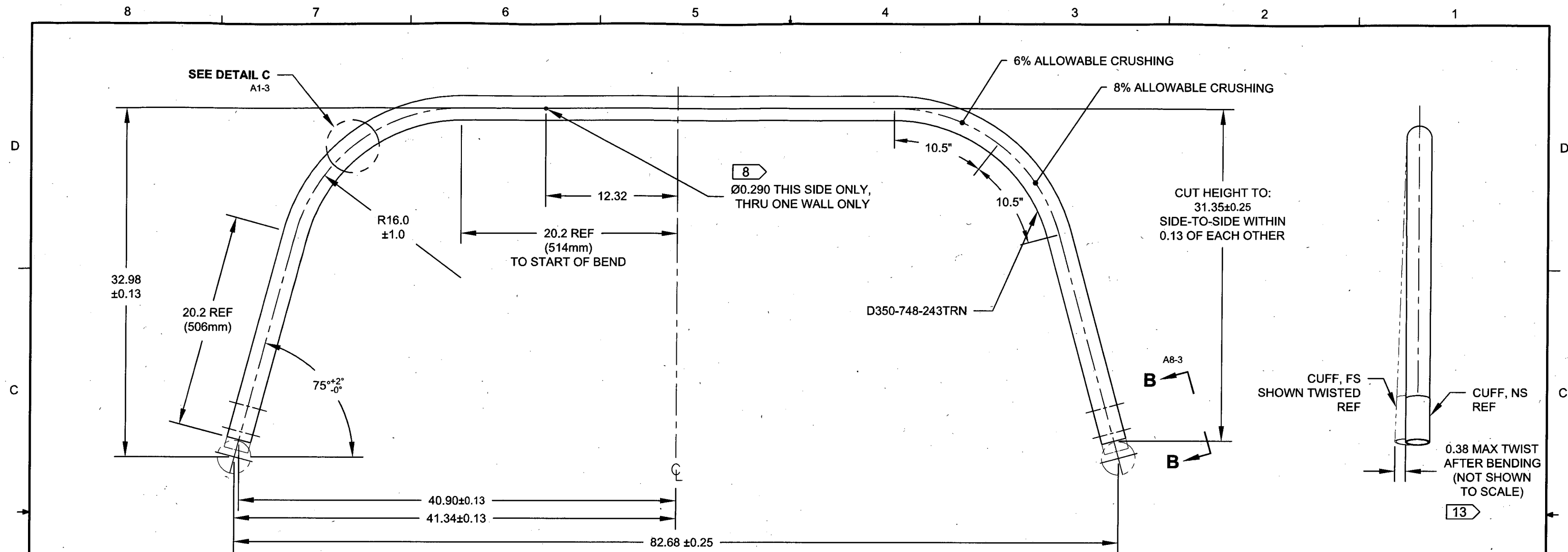
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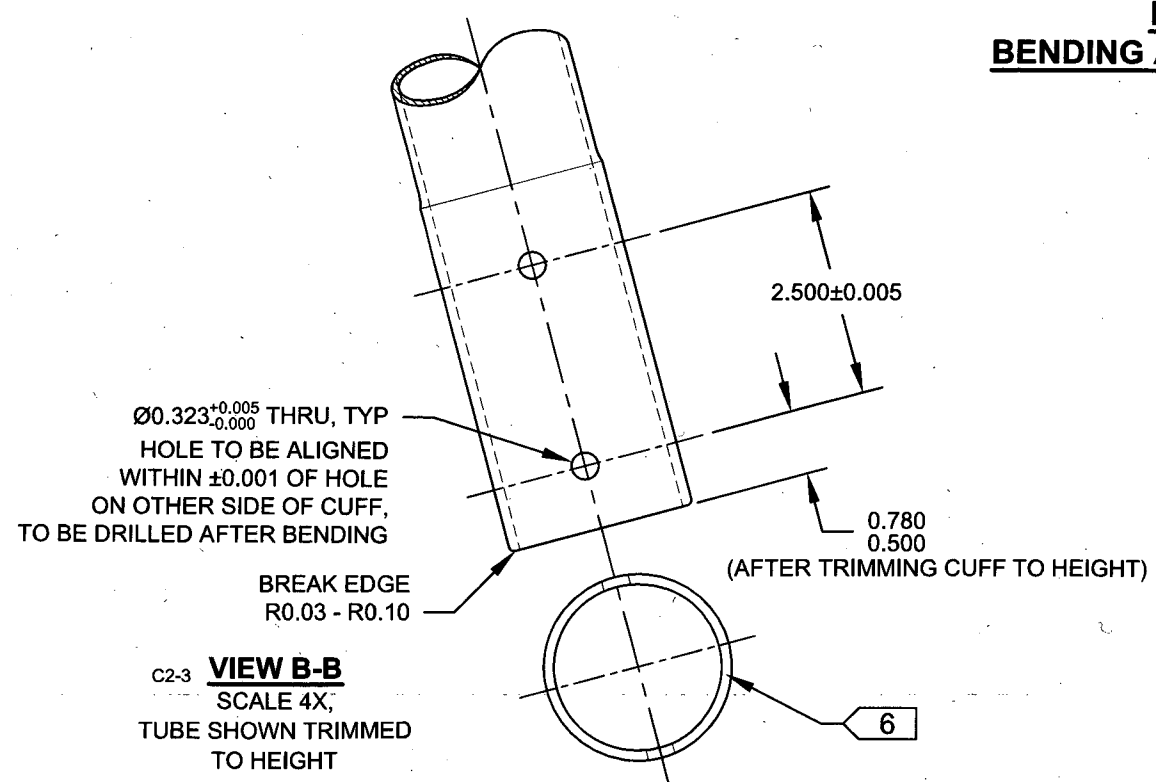
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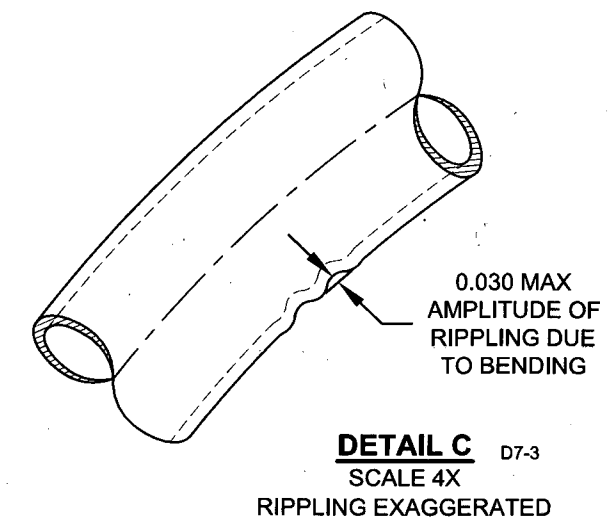
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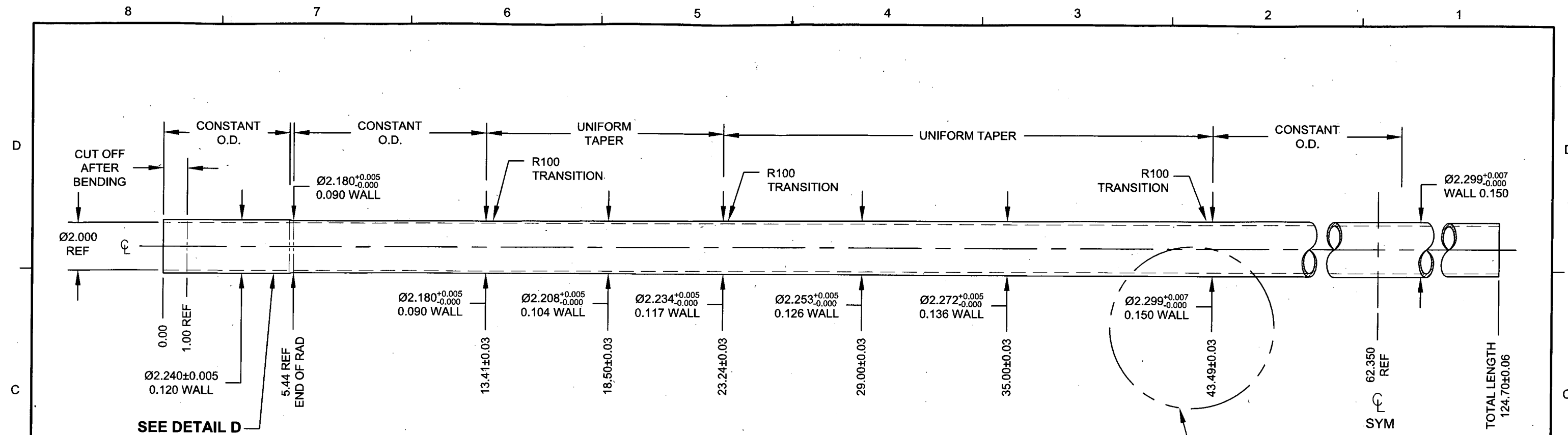
**D350-748-243
BENDING AND DRILLING DETAIL** 11



PRELIMINARY ISSUE
Rev. PA3 15/3/3



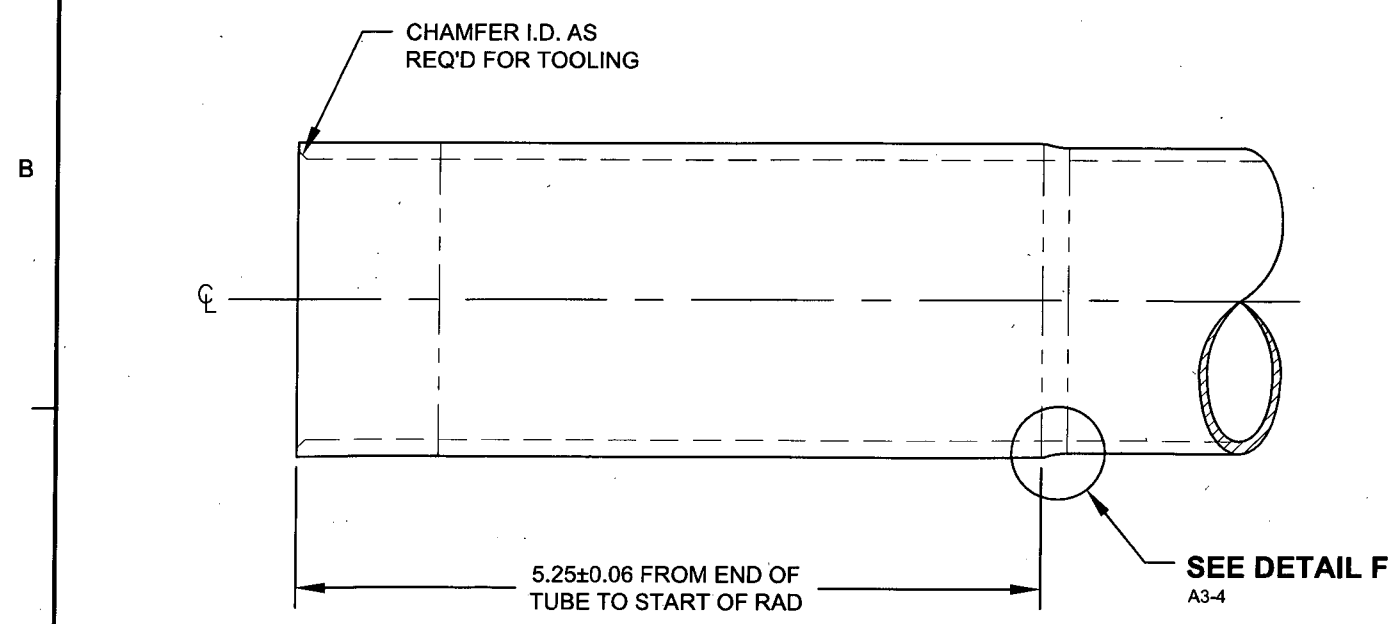
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DRAWN	q	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.		D350-748-243	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI AFT)	NTS
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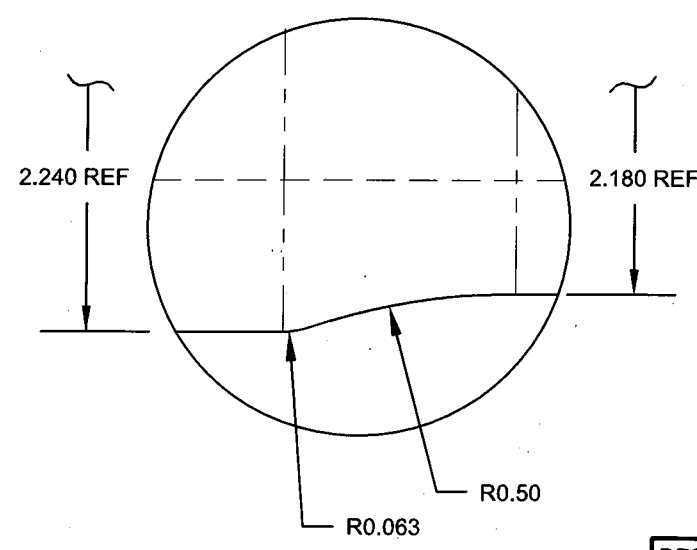
SEE DETAIL D
A6-4

SEE DETAIL E
A1-4

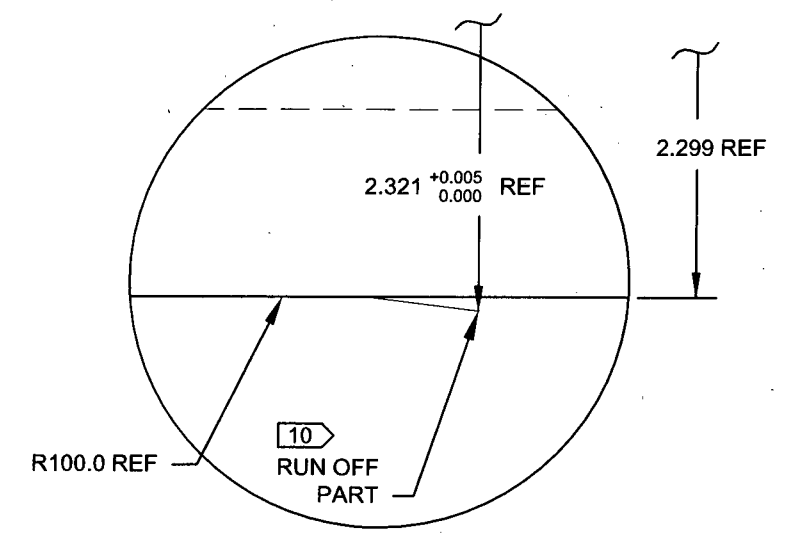
D350-748-243TRN
TURNING DETAIL



DETAIL D:
CROSSTUBE CUFF C7-4
SCALE 3X



DETAIL F:
CUFF TRANSITION A5-4
NOT TO SCALE



DETAIL E:
TAPER RUN-OFF C2-4
NOT TO SCALE

PRELIMINARY ISSUE
Rev. PA3 4/15/3/3

DESIGN	42	DART AEROSPACE LTD	
DRAWN	42	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.		D350-748-243	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI AFT)	NTS
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